

Work Order ID 81460***81460***

Wednesday, March 14, 2012 11:01:41 AM

Item ID: D4149-041

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Revision ID:

Item Name: Crosstube Lug Assembly, Aft

Start Date: 3/14/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/30/2012 Req'd Qty: 6.00

6

Customer:

Run Start ***NR1***Stop ***NR2***

Reference:

Approvals:

Process Plan: MPDate: 12-03-14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4149

C

0.00

100

100

Small Fab

Small Fab

Memo

1- Assemble as per dwg

0.00

QC5- Inspect part completeness to step on W/O

0.00

110

110

QC

Quality Control

Memo

0.00

Identify as per dwg & Stock Location: 468

0.00

120

120

Packaging

Packaging

Memo

0.00

EP 12/04/05 (E)(46)12/4/5605

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 14, 2012 11:01:41 AM

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Work Order ID: 81460

Parent Item: D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 6.00

Required Qty: 6.00

AN4C13A Purchased No

100 Each 130.0000 3 18

BOLT

Location

Loc Qty

Loc Code

ST357

130

120187

1

120423

129

MS20615-4M18

Purchased No

100 Each 314.0000 3 18

Rivet

Location

Loc Qty

Loc Code

ST323

314

118077

150

118543

164

NAS1149C0332R

Purchased No

100 Each 3,617.0000 4 24

Washer

Location

Loc Qty

Loc Code

ST297

3617

118354

551

119736

196

120648

2870

NAS1149C0432R

Purchased No

100 Each 2,618.0000 6 36

Washer

Location

Loc Qty

Loc Code

ST297

2618

117291

1618

119124

1000

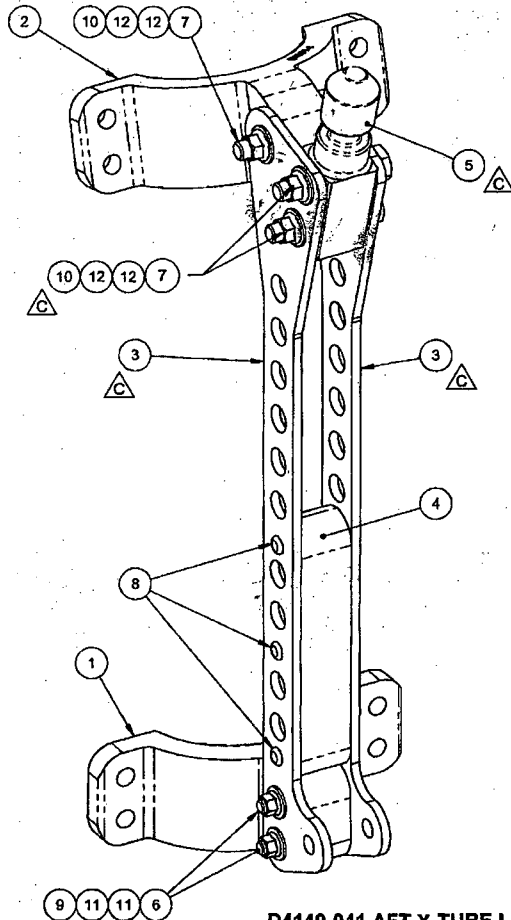
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D4149-041 AFT X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.21 lbs

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4149-041	AFT X-TUBE LUG ASSY
1	1	D3910-1	X-TUBE LUG
2	1	D4091-1	MOUNTING LUG
3	2	D4149-1	AFT X-TUBE LUG PLATE
4	1	D4149-3	SPACER
5	1	D4149-5	EYEBOLT STUD
6	2	AN3C12A	BOLT
7	3	AN4C13A	BOLT
8	3	MS20615-4M18	RIVET
9	2	MS21043C3	NUT
10	3	MS21043C4	NUT
11	4	NAS1149C0332R	WASHER
12	6	NAS1149C0432R	WASHER

C	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.250" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 WITH QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, D7-2)	SC	11.02.22
B	MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); ADDED D4149-5 (SHT 5); D4149-5 WAS D3909-5 (ZN D3-1 & D7-2); REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, C7-1, B7-2 & B7-2); 0.191 2 PL REPLACES 0.129 3 PL (ZN D5-3) REASON: SEE TR-D350-007/2 FOR B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.19
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS.
DATE	11.02.22	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

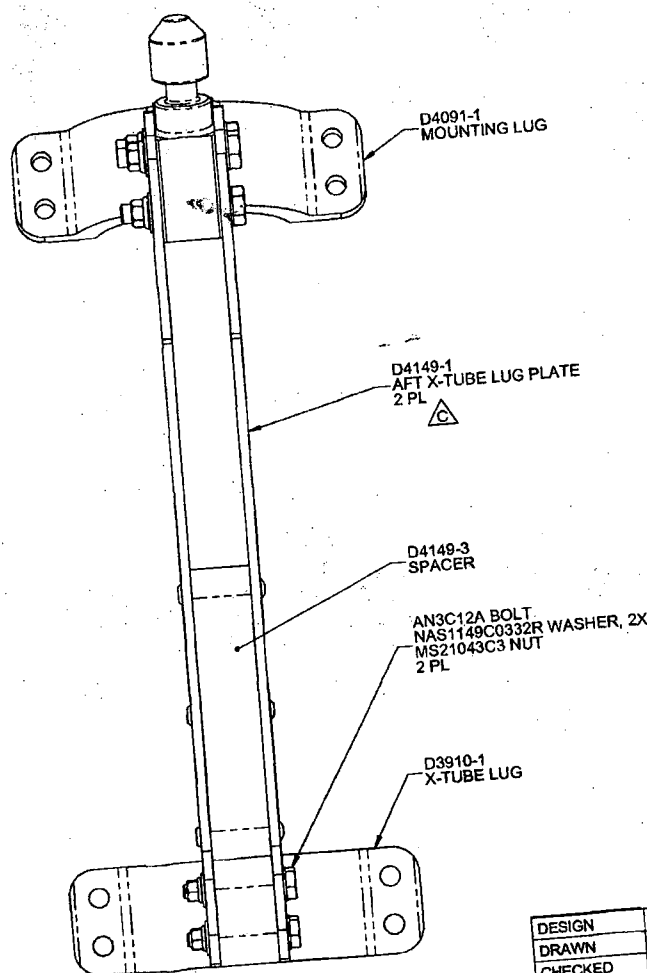
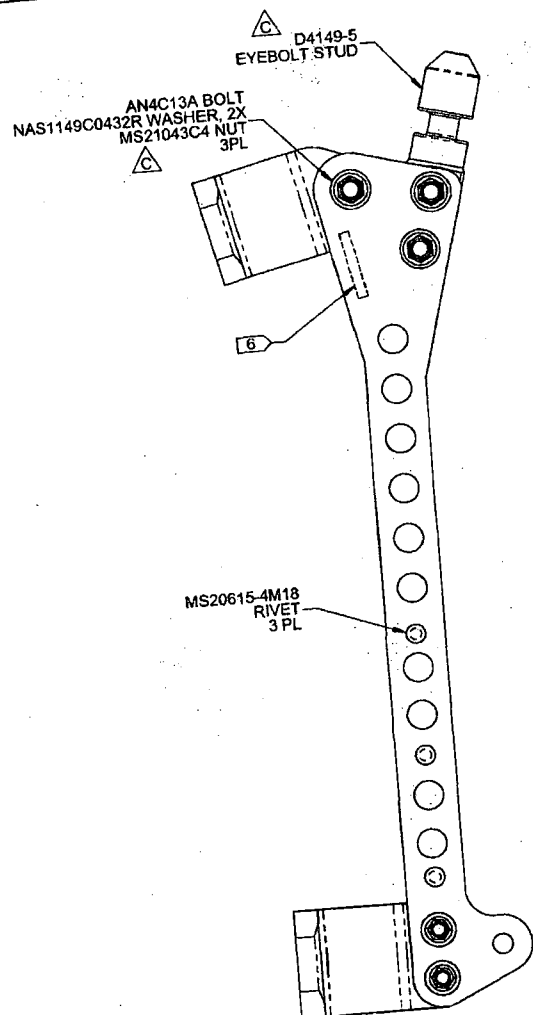
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D4149-041 AFT X-TUBE LUG ASSY

81460

RELEASED
2011-02-24

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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Dart Aerospace Ltd

WORK ORDER CHANGES

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DATE	STEP						

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